

Work Order ID 142926

Friday, March 11, 2016 3:15:01 PM

142926

Page 1

Item ID: D3326-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 3/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MLSDate: **MAR 14 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3326

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.04

Large Fab

1-Cut tubes as per Dwg D3326

2-Remove all markings from material and deburr as required check for foreign objects.

3-Drill and Weld as per Dwg D3324 & QSI 004
A/RN/ASteel Rod B127925

4-Deburr as required

1x 16 16-3-29

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

D 16-04-01

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER : _____							

Work Order ID 142926

142926

Friday, March 11, 2016 3:15:01 PM

Page 2

Item ID: D3326-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 3/14/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>m 134371</i>								
Powdercoat	Memo	0.00							
Powder Coating									

1ST COAT:
START TIME: 12:00
OVEN TEMPERATURE: 170°
FINISH TIME: 12:30
***** 2nd coat if necessary *****
2ND COAT:
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

1 8 16-04-4 **DAS 34 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Thursday, April 07, 2016

Details			
Raised Date 4/7/2016	Status Open	Owner Maranda, Denis	Number NCR16-5701
Target Date 5/13/2016	Standard		Severity
Process Employee finding		Audit	
Raised By Person Downing, Eric M		Raised Against (Department or Supplier) Manufacturing\Large Fab	Fault Category General\Positioned Wrong
Details was found during inspection that the D3326-041 (D350-721-043) B142926 that the D3348-1 attachment brackets were welded at the incorrect locations. they were welded at 56.00" and should be at 56.50" +/-0.01". it was also found that they were welded on two other finished painted & assembled baskets B142920 & B142921. all baskets were inspected and mistake was not found during inspections.			
Keywords		Product D350-721\D350-721-041	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 5/6/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	4/15/2016	
rework basket B142926 to be as per drawings. Remove D3348-1 (qtyx4) grind welds flush and reposition new D3348-1 x4 as per drawing. <i>CPC 16.4.11</i>		DAS 22 9-89 OK TO PROCEED	16.04.07
4	Duval, Patrick	4/22/2016	
perform trail fit on both painted & assembled baskets B142920 & B142921 to confirm if mounting brackets need removing.		DAS 51	SAN 16/04/07
5	Downing, Eric M	4/22/2016	
if necessary create RS to rework baskets			

6	Duval, David	4/22/2016	
update all D3326-041 work orders to have note to weld D3348-1 as per detail C at step # 100			

Verification & Review

Target Date 5/6/2016	Owner Downing, Eric M	Closed Date	Closed By
--------------------------------	---------------------------------	--------------------	------------------

Details

Actions

Number	Owner	Target Date	Completed Date
Details	Response		

Work Order ID 142926

Friday, March 11, 2016 3:15:01 PM

142926

Page 3

Item ID: D3326-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Base Assembly

Stop ***NS2***

Start Date: 3/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 x of all 16/04/16
DAS
15
9-89

150

Identify as per dwg & Stock Location: w/o

0.00

150

Packaging

Memo

0.00

Packaging

D350-721-043 / 13 142923 1x
1 x of all 16/04/16

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MUS APR 21 2016

MUS APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER : _____									

Picklist Print

Friday, March 11, 2016 3:15:01 PM

Page 1

Work Order ID: 142926

Parent Item: D3326-041

Parent Item Name: Basket Base Assembly

142926

D3326-041

Start Date: 3/14/2016

Required Date: 3/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	480.0000	30.75	32.36842			

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA004

480

123339

167

m132313

313

33

M569EX0.50-18F

Purchased

No

100

sf

66.0000

28

28

M569FX0 50-18F

569 Expanded Metal

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA006

66

B134534

28

120204

33

123293

33

D3328-3

Manufactured

No

100

Each

18.0000

2

2

D3328-3

Basket Hinge

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA004

18

33872

6

86891

12

2x

D3348-1

Manufactured

No

100

Each

8.0000

4

4

D3348-1

Clevis

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA004

8

B142945

74727

8

4x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, March 11, 2016 3:15:01 PM

Page 2

Work Order ID: 142926

Parent Item: D3326-041

Parent Item Name: Basket Base Assembly

142926

D3326-041

Start Date: 3/14/2016

Required Date: 3/18/2016

Start Qty: 1.00

Required Qty: 1.00

D3349-3

Manufactured No

100

Each

16.0000

2

2

D3349-3

Spacer Bushing

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA004

16

109548

12

75620

4

2x

D3367-1

Manufactured No

100

Each

9.0000

2

2

D3367-1

Mounting Bracket

**

CC 16-3-23

Location

Loc Qty

Loc Code

WA004

9

3

6

125194

132542

B142944

1x

1x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

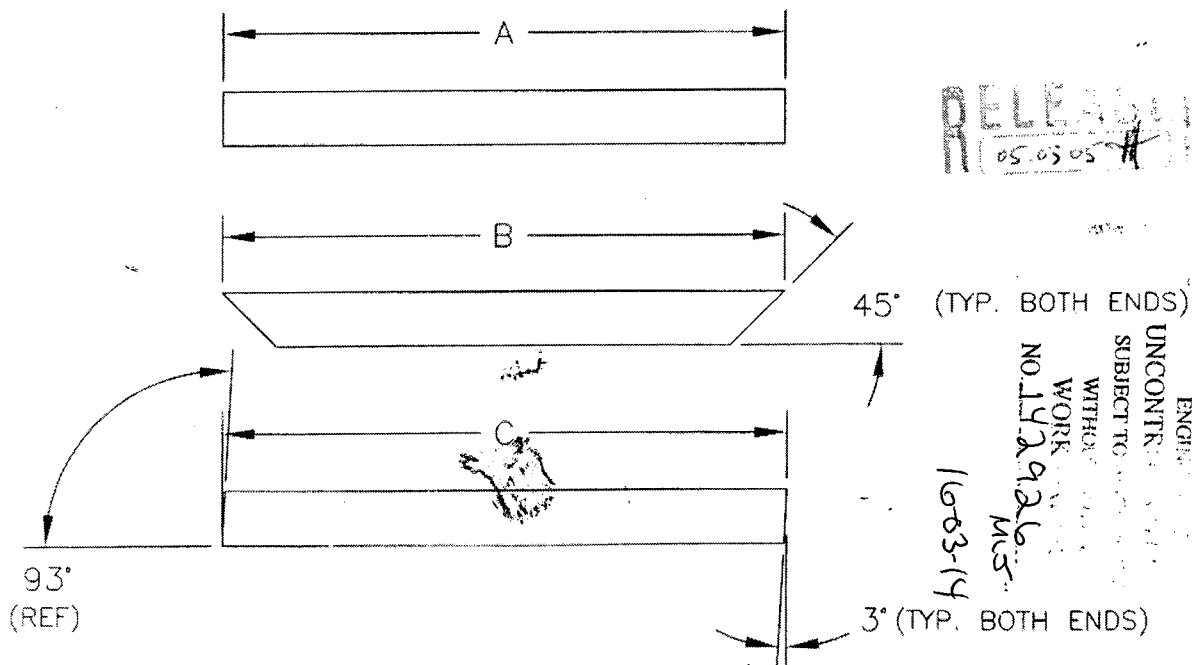
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3326	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.21	NEW ISSUE	
B	05.03.04	UPDATE TUBING AND MESH MAT'L SPEC	

PARTS LIST FOR D3326-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3326-1	1	14.00	N/A	N/A	BOTTOM TUBE
D3326-3	4	N/A	56.50	N/A	FULL LENGTH TUBE
D3326-5	2	N/A	16.00	N/A	TOP END TUBE
D3326-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3326-9	6	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3326-1/-3/-5/-7/-9

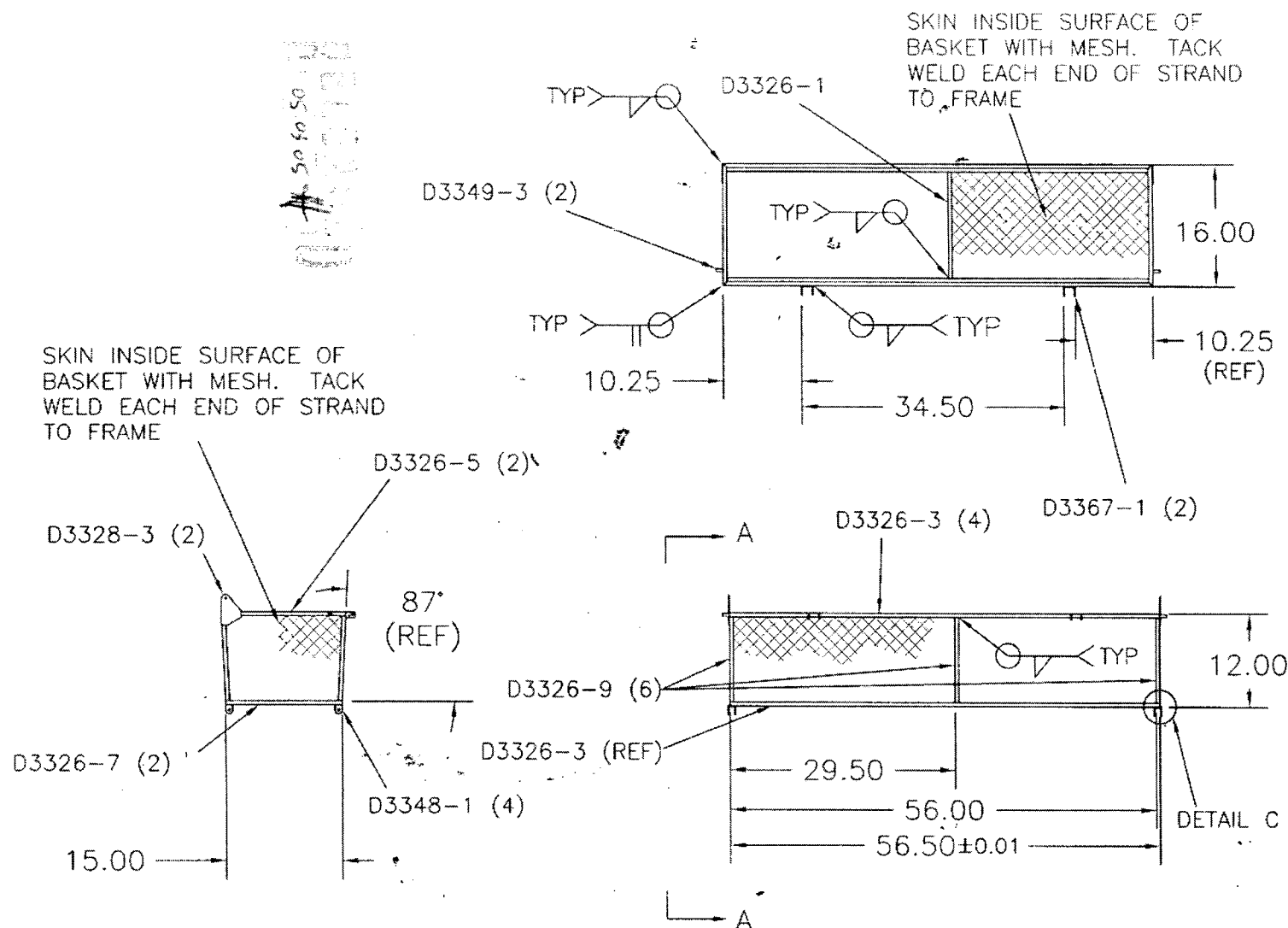
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130-TS0.500W.035)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN	44	DRAWN BY	44	DART AEROSPACE LTD
CHECKED	44	APPROVED	44	HAWKSBURY, ONTARIO, CANADA
DATE	05.03.04	TITLE	D3326	REV. B
			BASKET BASE ASSEMBLY	SHEET 2 OF 3
				SCALE 1:25

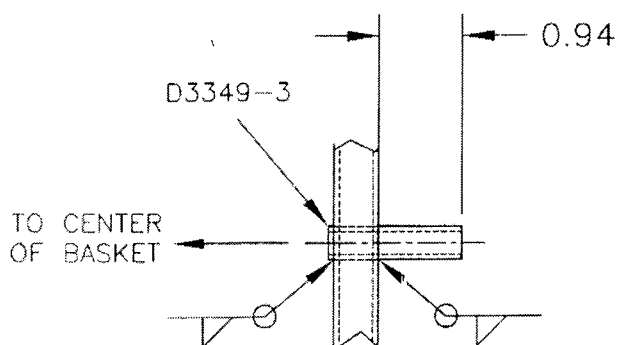
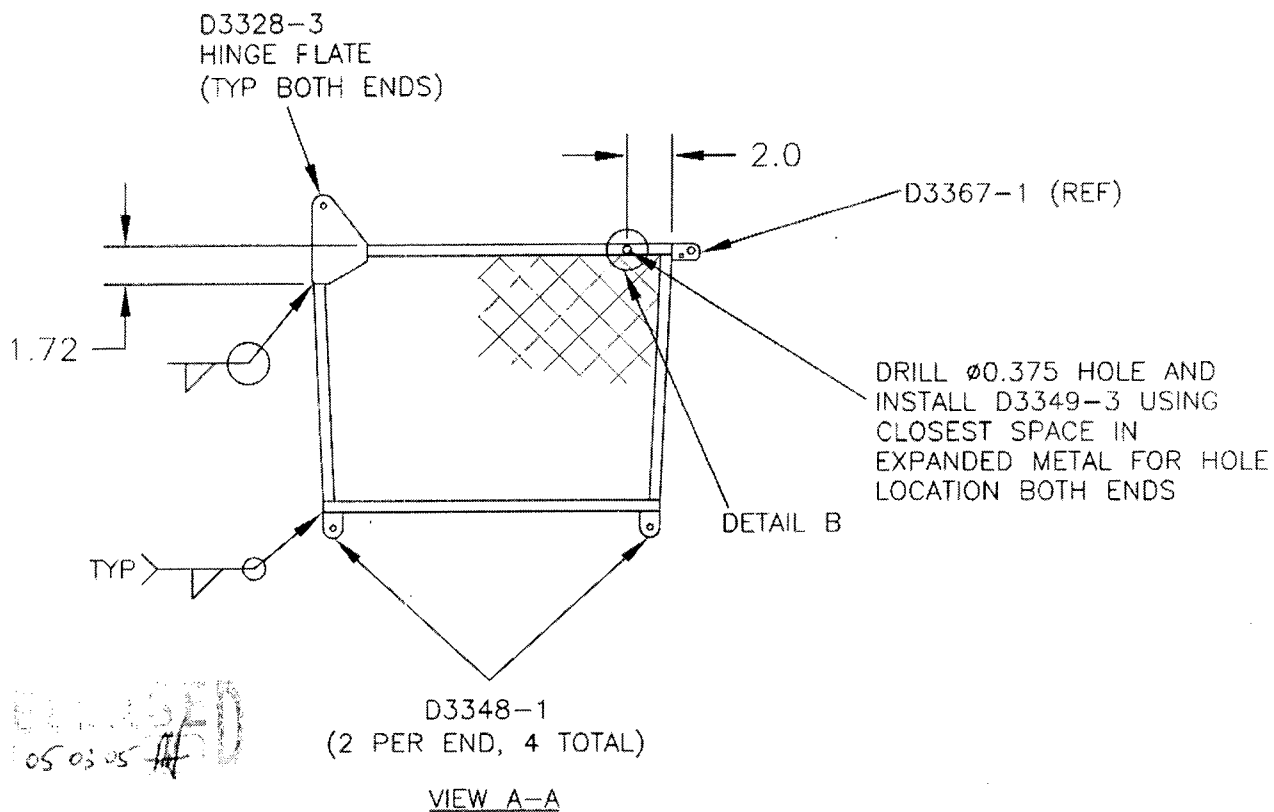


D3326-041 BASKET BASE ASSEMBLY

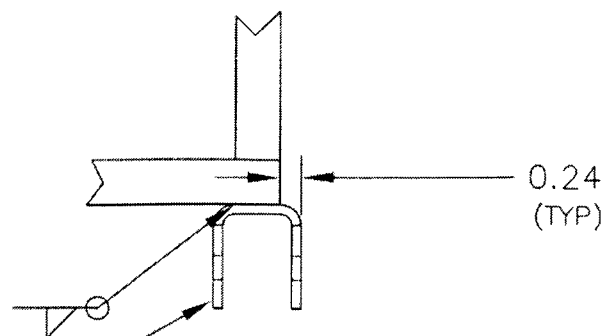
- 1) MESH MATERIAL: 1/2" - 18 GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3326	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



D3348-1
(2 PER END, 4 TOTAL)



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DART AEROSPACE LTD	Work Order: 142926
Description: Repair Scheme for NCR16-5701 mounting lugs installed incorrectly	
Drawing: D3326-041	Repair Scheme: RS1031
Part No: D350-721-044	Page: 1 of 1
Batch No: B14290 & B14291	Qty: ①

Step	Location	Procedure	By	Date	Qty
1	Finishing	Pull parts as per NCR16-5701 + D3326-041 D350-721-043 B142920 & B142921 B142926	PD	16-04-11 DAS	①
2	Finishing	Remove all hardware from baskets Label parts to be reassembled per b# of each basket	U/A	9 9-89	
3	Large Fab / Baskets	Remove all D3348-1 qty x4 from D3326-041 basket base	CC	16-4-11	
4	Large Fab / Baskets	Grind welds flush. Ensure that tuping is not ground thin.	CC	16-4-11	
5	Quality	QC5 verify work to ensure that the material is not too thin	PD	16-04-18	
6	Large Fab / Baskets	Pull D3348-1 qty x4 B 142945	CC	16-4-11	
7	Large Fab / Baskets	Re weld as per Drawing D3326 & per QSI004 D3348-1 in correct location A/R 4130 Steel Rod B125925	CC	16-4-11	
8	Quality	QC 9 & 5 and perform a trial fit to ensure that D3348-1 are in correct locations	PD	16-04-18	
9	Finishing	Suff all basket base	283 BR	16-04-18	①
10		Re powder coat as per QSI004 Powder Coat 17.134371. Start time 1.30 Oven temp 400° Finish time 2.00 DAS 15 9-89	BR	16-04-18	
11		QC3 inspect Powder coat finish	15 9-89	16/04/14	1
12	Finishing	Re assemble basket as per drawing List all parts that need replacing	#	16-04-18	1
13	Quality	QC5 inspect assembly	PD	16-04-25	1
14	Stores	Put kit back into baskets			
15	Quality	QC4 Ensure that correct kit is with basket Verify all labels are correct			
16	Stores	Identify & stock	* SMTS HLS	16/04/22	
17	Quality	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	2016.04.08	New Issue	ED	PD	JP